

Work Order ID 71629

Thursday, July 07, 2011 11:21:33 AM



Page 1

Item ID: D3259-5	Accept		Setup	Start	
Revision ID:				Stop	
Item Name: Spacer					
Start Date: 7/7/2011	Start Qty: 12.00		Cust Item ID:		
Required Date: 7/21/2011	Req'd Qty: 12.00		Customer:		
Reference:					

Approvals:	Process Plan: <u>MF</u>	Date: <u>11-07-07</u>	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3259	Rev B								

100		0.00							
	FLOW WATER JET								
Waterjet	Memo	0.00							
FLOW CNC Waterjet	1-Cut as per Dwg D3259 <input type="checkbox"/> Dwg Rev: <u>B</u> <input type="checkbox"/> Prog Rev: <u>B</u> <input type="checkbox"/> 2- Deburr if necessary								
2024 . 032									

110		0.00							
	QC2- Inspect parts off machine FAI/FAIB								
QC	Memo	0.00							
Quality Control									

120		0.00							
	QC8- Inspect parts - second check								
QC	Memo	0.00							
Quality Control									

B 11-8-15

(12)

B 11-8-5

5 n/08/16

(4/2)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Item ID: D3259-5

Accept



Setup Start



Revision ID:

Stop



Item Name: Spacer

Start Date: 7/7/2011 Start Qty: 12.00



Cust Item ID:

Required Date: 7/21/2011 Req'd Qty: 12.00

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130 Chemical Conversion Coat per QSI005 4.1 0.00



HandFinish Memo 0.00

Hand Finishing

12 9 91 u/08/16

140 QC3- Inspect Part Finish 0.00



QC Memo 0.00

Quality Control

12x 0 m/4/08/16

150 Identify as per dwg & Stock Location: 180A 0.00



Packaging Memo 0.00

Packaging

11/8/17 5 (12)

W/O:		WORK ORDER CHANGES					
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Item ID: D3259-5

Accept



Setup Start



Revision ID:

Stop



Item Name: Spacer

Start Date: 7/7/2011 Start Qty: 12.00



Cust Item ID:

Required Date: 7/21/2011 Req'd Qty: 12.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/8/18 JJ

11-08-18
(12)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

Thursday, July 07, 2011 11:21:30 AM

Page 1

Work Order ID: 71629

Parent Item: D3259-5

Parent Item Name: Spacer





Start Date: 7/7/2011

Required Date: 7/21/2011

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP Rev:A New Issue 07-07-19 JLM Verified By:EC IPP REV
B:AS PER REV B 10-05-19 JLM VERIFIED BY:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M2024T3S.032 		Purchased			No			100	sf	24.4000	1.388	17.53263	16.6
												11-8-13	

2024-T3 .032 sheet

Location

Loc Qty

Loc Code

MAT22

24.4

111699

0.5

113189

23.9

113189

12

W/O:		WORK ORDER CHANGES					
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DART AEROSPACE LTD		Work Order: 71629
Description: Spacer		Part Number: D3259-5
Inspection Dwg: D3259 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
9.000	+/-0.005	8.994	L		PROWSE	
1.000	+/-0.005	.994	✓		V BOZ	
5.000	+/-0.005	4.916	✓		U	
12.000	+/-0.005	12.000	✓		P	
3.5000	+/-0.005	3.494	✓		V	
0.875	+/-0.005	.877	✓		V	
0.260	+/-0.010	.260	✓		V	
R0.50	+/-0.030	.50	✓		R.G	
0.250	+/-0.010	.250	✓		V	
0.875	+/-0.005	.876	✓		V	
Ø0.098	+0.005/-0.000	.101	✓		V	
0.550	+/-0.010	.558	✓		V	
R0.50	+/-0.030	.50	✓		R.G	
10.062	+/-0.010	?	✓			
R0.13	+/-0.030	.13	✓		R.G	
0.032 thick	+/-0.010	.033	✓		V	
0.130	+/-0.010	.130	✓		V	

Measured by: B	Audited by: S	Preliminary Approval:
Date: 11-8-15	Date: 11/08/16	Date:

Rev	Date	Change	Revised by	Approved
A	04.08.25	New Issue P/O D412-705-019	KJ/JLM	
B	10.06.07	Dwg Rev updated	KJ	

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